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Livestock and  
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**I** **NSTITUTIONAL**

**M** **EAT**

**P** **URCHASE**

**S** **PECIFICATIONS**

**QUALITY ASSURANCE PROVISIONS  
APPROVED BY USDA**

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***This June 1997 edition includes all previous page changes.***

# INSTITUTIONAL MEAT PURCHASE SPECIFICATIONS

## QUALITY ASSURANCE PROVISIONS

The United States Department of Agriculture (USDA) through its Agricultural Marketing Service (AMS) develops and maintains the Institutional Meat Purchase Specifications (IMPS) for meat and meat products. The complete IMPS series includes the following ten documents:

### General Requirements

Fresh Beef .....	Series 100
Fresh Lamb and Mutton .....	Series 200
Fresh Veal and Calf .....	Series 300
Fresh Pork .....	Series 400
Cured, Cured & Smoked, & Fully Cooked Pork Products .....	Series 500
Cured, Dried, and Smoked Beef Products .....	Series 600
Edible By-Products .....	Series 700
Sausage Products .....	Series 800

### Quality Assurance Provisions

These specifications are recommended for use by any meat product procuring activity. For assurance that procured items comply with these detailed requirements, the USDA, through its Meat Grading and Certification Branch, provides a voluntary Meat Certification Service. For labeling purposes, only product Certified by the Meat Grading and Certification Branch (MGCB) may contain the letters "IMPS" on the product label. Purchasers desiring this service should contact:

USDA, AMS, Livestock and Seed Division  
Meat Grading and Certification Branch  
Stop 0248 Room 2628 S-Bldg  
1400 Independence Ave. SW  
Washington, D.C. 20250-0254 Phone: (202) 720-1113

For any assistance regarding these documents and for additional copies, please contact:

USDA, AMS, Livestock and Seed Division  
Livestock and Meat Standardization Branch  
Stop 0254 Room 2628 S-Bldg  
1400 Independence Ave. SW  
Washington, D.C. 20250-0254 Phone: (202) 720-4486

# I. SCOPE

All IMPS items shall meet the requirements specified in the IMPS Item Descriptions, IMPS General Requirements and purchasing documents. The Quality Assurance Provisions are to be used by the MGCB for certification of compliance with the detailed item descriptions. These provisions are recommended for use by any meat production Quality Control activity. Examination for time limitations and packing and packaging requirements shall be performed as stated in the IMPS General Requirements.

# II. DEFINITION OF TERMS

For the purpose of determining acceptance of any IMPS item, the following definitions are provided:

**Acceptable Quality Level (AQL).** The maximum number of defects per hundred units that, for the purposes of sampling inspection, can be considered satisfactory as a process average.

**Acceptance Number (Ac).** The number in a sampling plan that indicates the maximum number of defects permitted in a sample in order to consider a lot as meeting a specific AQL.

**Boneless.** All bone, cartilage, and calcified periosteum shall be considered when evaluating defects for presence of bone and cartilage.

**Defect.** Any nonconformance of any unit of product with specified requirements.

**Defect Classifications.** The terms used to denote the severity of a defect. The terms are as follows:

Major defect - A defect that materially affects, or is likely to materially affect, the usability of the item.

Minor defect - A defect of which repeated occurrence would materially affect, or is likely to materially affect, the usability of the item.

**Lot.** The term is used to mean a collection of units of meat products that are offered for examination for determination of compliance during a single workshift and are of the same item description, weight range, date of acceptance, etc. For the purpose of these provisions the size of a lot shall be expressed in applicable terms of either pounds or pieces.

**Random sampling.** A process of selecting a sample from a lot whereby each unit in the lot has an equal chance of selection.

**Rejection Number (Re).** The number in a sampling plan that indicates the minimum number of defects in a sample that will cause a lot to fail a specific AQL.

**Sample.** The collective number of sample units for the examination of a lot.

**Sample Size.** The number of sample units which are to be included in the sample.

**Sample unit.** An individual item (roast, chop, steak, etc.) or designated quantity of product to be part of a sample.

**Slight amount of lean removed.** Amount of lean removed from the major muscles of an item that, regardless of the location, is indicative of a product prepared within the limits of good commercial practice and does not materially affect the usability of that item.

**Small amount of lean removed.** Amount of lean removed from the major muscles of an item that, regardless of the location, materially affects the usability of that item.

**Stationary Lot Sampling plan.** A plan stating the number of sample units to be included in the sample as well as the corresponding acceptance and rejection criteria. The decision to accept or reject a lot with respect to a specified AQL is made after the inspection of a sample or when the number of defects exceeds the acceptance number.

**100-Percent.** A method of examination in which all items within a lot are examined. Items not fully complying with the detailed item description shall be rejected.

### III. PRODUCT EXAMINATION

Fresh-chilled bone-in or boneless meat shall be examined for excellent condition and detailed item description requirements using either the 100 percent or the stationary lot examination procedure. Certification for excellent condition and detailed item description requirements may be performed separately or at the same time. Certification for excellent condition on ground, flaked, diced or portioned items shall be determined on the applicable raw materials prior to preparation of the product in its final form (i.e., prior to grinding, flaking, dicing, portioning). Certification of excellent condition of sausage items, to be delivered frozen, may be performed on thawed samples after freezing/tempering, provided the producer is a participant in the MGCB sponsored quality control program.

The examination procedure used shall be specified by the contractor and agreed to by the AMS agent. Lot sizes shall be as defined for each procedure. However, the AMS agent may designate a portion of a declared lot as a separate lot, if in the agent's opinion: (1) that portion is not in compliance with any of the specification requirements; (2) if production is seriously interrupted; or (3) if there is excessive recurrence of units not in compliance with detailed item descriptions during 100 percent examination. The AMS agent may specify the examination procedure to be used for such lots.

## A. CONTRACTOR'S RESPONSIBILITY

Examination and certification by AMS shall not relieve the contractors of their obligation to deliver product complying with all the requirements of the Institutional Meat Purchase Specifications. The contractor shall assure product compliance prior to submitting it for any examination.

Determination of wholesomeness and acceptability of meat with respect to the presence of foreign material (e.g., glass, dirt, insect parts, hair, wood, or metal) shall be made by a Food Safety Inspection Service (FSIS) Meat and Poultry Inspection Operations (MPIO), employee.

## B. PROCEDURES FOR EXAMINATION

100-Percent. This procedure may be used to initially examine fresh-chilled bone-in or boneless meat for excellent condition requirements, prior to further processing, provided the meat is in portions of at least 3 pounds (1.4 kg). Lots that contain any meat in portions that are less than 3 pounds shall be examined by the Stationary Lot procedure unless the stationary lot sample size exceeds the lot size.

The 100 percent examination procedure may be used for determining compliance with excellent condition and the detailed item description requirements for carcasses, sides, quarters, and large bone-in or boneless primal cuts (See applicable index for items eligible to be examined 100-Percent). This examination is also allowed for other cut and roast items (except portion cuts) and boneless meat for further processing when the lot size is less than 500 pounds.

All meat in less than excellent condition shall be rejected and cannot be reworked and/or reoffered. Items which do not meet all the detailed item description requirements shall be rejected, but they may be reworked and reoffered one time only.

Stationary Lot. This procedure may be used to examine fresh-chilled bone-in or boneless meat of any size portion (cuts and/or trimmings) for excellent condition and detailed item description requirements. The lot size, expressed in terms of number of pounds, shall be declared to the AMS agent by the contractor. Lot size shall not exceed the amount of product offered in a single workshift. The sampling plans for meat are listed in the Lot Acceptance Criteria section.

The randomly selected sample units shall be evaluated for compliance with the excellent condition criteria (if not previously examined for condition) and applicable defect classification table found in section **IV. DEFECT CLASSIFICATIONS**. Failure of the sample to meet the acceptance criteria as identified in Lot Acceptance Criteria section shall cause rejection of the involved lot.

Rejected product, (except sausage items) may be offered for reexamination once as one stationary lot (refer to Lot Acceptance Criteria section). Meat shall be reworked prior to reexamination. However, lots containing product in less than excellent condition shall be rejected and cannot be reworked and reoffered. Except as otherwise specified, Quality Assurance **TABLE I-B and II-B** shall not be applicable to IMPS 800 Sausage products.

IMPS Quality Control Program (IMPS QCP). The IMPS QCP program, involves the implementation of plant-wide quality control in combination with a USDA, MGCB certification program. Approved IMPS QCP participants shall be authorized to present fresh chilled, or tempered/frozen uncooked sausage IMPS items to the AMS agent for an excellent condition examination and product acceptance determination in its final form (i.e., after tempering/freezing).

IMPS QAP applicants shall submit, in writing, a completed application of their proposed IMPS quality control program (EXHIBIT A) to their local Area Meat Grading Supervisor for review. The Area Meat Grading Supervisor shall then evaluate and approve, or disapprove, each individual proposal based on the following criteria:

1. The application demonstrates that the finished IMPS item will meet all IMPS specification and Quality Assurance requirements.
2. The producer has at least one full time employee responsible for ensuring that the quality control program is strictly enforced and that a responsible employee is fully qualified to supervise a quality assurance program.
3. The producer maintains and makes available for review all manifest, production and quality control records.

MGCB maintains the right to verify any of the information provided by the contractor.

IMPS QCP participants found not to be adhering to the approved quality control plan shall be suspended from the program for a minimum of 6 months or until necessary corrections have been made and approval for reinstatement has been granted by the local Area Meat Grading supervisor. IMPS QCP suspended contractors shall be required to offer all future product for initial examination in the fresh chilled state until the suspension has been lifted.

Randomly selected sample units shall be thawed above 36°F (2.2°C) and shall be evaluated for compliance with the excellent condition criteria and applicable defect classification table. Failure of the sample to meet the acceptance criteria as identified in the Lot Acceptance Criteria section shall cause rejection of the involved lot. Product which has been thawed shall be returned to the vendor and may not be included in the acceptable delivery unit. Contractors shall replace the thawed product with additional product produced for this purpose. Copies of the approved quality control plan shall be maintained at the production plant, and at the Area, Regional, and Washington, D.C., MGCB office.

Product Monitoring - When specified by the purchaser, acceptability of boneless meat for compliance to the material requirements for ground meat and trimmings shall be determined in accordance with a product monitoring program. For certification, the boneless meat product monitoring shall be performed in accordance with MGCB 918 instruction for boneless meat examinations. The applicable IMPS defect classification table shall be used to determine compliance with the material requirements for ground meat and trimmings.

## C. LOT ACCEPTANCE CRITERIA

**Cuts, roasts and diced items.** Unless otherwise specified by the purchaser, the following AQL's in TABLE I shall be used. Major and minor defects are classified within the applicable defect classification table found in Section **IV. DEFECT CLASSIFICATIONS**. The accept (AC) and reject (RE) criteria for the respective AQL's are within TABLE I-A. TABLE I-B shall be used for examination of cuts, roast, and diced items which have been rejected and reworked.

The sample size may differ depending on the specified or required AQL. For example, if sample size for Major defects equals 13 sample units and the sample size for Minor defects equals 8, then 8 randomly selected sample units out of the 13 may be examined for both Major and Minor defects and the remaining sample units shall be examined for Major defects only.

**Portion cuts.** Unless otherwise specified by the purchaser, the AQL in TABLE II shall be used. Major and minor defects are classified within the applicable defect classification table found in Section **IV. DEFECT CLASSIFICATIONS**. The accept (AC) and reject (RE) criteria for the respective AQL are within TABLE II-A. TABLE II- B shall be used for examination of portion cut items which have been rejected and reworked.

### **IMPS 800 Series Sausage Products**

**Stick, loaf, sliced, link, crumbled, scrapple, roll, bag, and bulk packaged product -** Lot size, sample size, and accept/reject criteria shall be as shown in **TABLE I-A**. The lot size shall be expressed as the number of pounds. A sample unit shall be 1 item or 1 pound (0.45 kg) as specified.

**Patty products -** Lot size, sample size, and accept/reject criteria shall be as shown in **TABLE II-A**. The lot size shall be expressed as number of pounds. A sample unit shall be 1 portion item.

**Reexamination of rejected lots -** Except as otherwise specified, Quality Assurance **TABLES I-B and II-B** are not applicable to IMPS Series 800 Sausage products.

## **STATIONARY LOT SAMPLING PLANS**



**TABLE I**

DEFECT CLASSIFICATION		AQL
MAJOR		6.5
MINOR		25.0

**TABLE I-A  
STATIONARY LOT SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ 6/  
FOR CUTS AND ROASTS**

		AQL'S											
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	4.0		6.5		10		15		25		40	
		AC	RE	AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
1,200 OR LESS	8	----		1	2	2	3	3	4	5	6	7	8
	13	1	2	----		----		----		----		----	
1,201 TO 3,200	13	1	2	2	3	3	4	5	6	7	8	10	11
3,201 TO 35,000	20	2	3	3	4	5	6	7	8	10	11	14	15
35,001 OR MORE	32	3	4	5	6	7	8	10	11	14	15	21	22

**TABLE I-B  
STATIONARY LOT SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ 7/  
FOR CUTS AND ROASTS  
REEXAMINATION**

		AQL'S											
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	4.0		6.5		10		15		25		40	
		AC	RE	AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
1,200 OR LESS	8	----		----		1	2	2	3	3	4	5	6
	13	----		1	2	----		----		----		----	
	20	1	2	----		----		----		----		----	
1,201 TO 3,200	13	----		1	2	2	3	3	4	5	6	8	9
	20	1	2	----		----		----		----		----	
3,201 TO 35,000	20	1	2	2	3	3	4	5	6	8	9	12	13
35,001 OR MORE	32	2	3	3	4	5	6	8	9	12	13	18	19

NOTE: Footnotes 1 - 6 are applicable to TABLES I-A, II-A, Footnotes 1 - 5 are applicable to TABLES II-B, I-B.

- 1/ The finding of any product in less than excellent condition shall cause rejection of the involved lot.
- 2/ When sampling is performed on items that are packed into containers, no more than 2 cuts or roast, and ten portion-cut sample units from one container may be included in the sample.
- 3/ Acceptability of product with respect to presence of foreign material (for example: glass, dirt, insect parts, hair, wood, metal) shall be made by an MPIO employee.
- 4/ Presence of product not within specified quality and/or yield grade, proper identity, or fabricated and/or placed into containers as specified shall cause rejection of the lot.
- 5/ The "----" in the table AQL columns indicates that AC, RE criteria are not available for that AQL. Use the alternate sample size and AC, RE criteria listed for that AQL.
- 6/ When sampling is performed on Series 800 Sausage Items, (**except Item No. 802A and 802B - see footnote 2**) no more than 5 sample units, from a single primary container may be included in the sample.
- 7/ TABLES I-B and II-B are not applicable to Series 800 Sausage Items.

# TABLE II

## DEFECT CLASSIFICATION

AQL

MAJOR  
MINOR

6.5  
25.0

### TABLE II-A STATIONARY SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ FOR PORTION CUTS

		AQL'S									
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	4.0		6.5		10		15		25	
		AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
500 OR LESS	20	2	3	3	4	5	6	7	8	10	11
501 TO 1,200	32	3	4	5	6	7	8	10	11	14	15
1,201 TO 3,200	50	5	6	7	8	10	11	14	15	21	22
3,201 TO 10,000	50	----		----		----		----		21 22	
	80	7	8	10	11	14	15	21	22		
10,000 OR MORE	50	----		----		----		----		21 22	
	80	----		----		----		21 22		----	
	125	10	11	14	15	21	22	----		----	

### TABLE II-B STATIONARY LOT SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ 7/ FOR PORTION CUTS REEXAMINATION

		AQL'S									
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	4.0		6.5		10		15		25	
		AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
500 OR LESS	20	1 --- 2		1 --- 2		3 --- 4		5 --- 6		8 --- 9	
	32	1	2	----		----		----		----	
501 TO 1,200	32	1	2	3	4	5	6	8	9	12	13
1,201 TO 3,200	50	3	4	5	6	8	9	12	13	18	19
3,201 TO 10,000	50	----		----		----		----		18 19	
	80	5	6	8	9	12	13	18	19	----	
10,001 OR MORE	50	----		----		----		----		18 19	
	80	----		----		----		18 19		----	
	125	8	9	12	13	18	19	----		----	

NOTE: Footnotes 1 - 6 are applicable to TABLES I-A, II-A, Footnotes 1 - 5 are applicable to TABLES II-B, I-B.

- 1/ The finding of any product in less than excellent condition shall cause rejection of the involved lot.
- 2/ When sampling is performed on items that are packed into containers, no more than 2 cuts or roast, and ten portion-cut sample units from one container may be included in the sample.
- 3/ Acceptability of product with respect to presence of foreign material (for example: glass, dirt, insect parts, hair, wood, metal) shall be made by an MPIO employee.
- 4/ Presence of product not within specified quality and/or yield grade, proper identity, or fabricated and/or placed into containers as specified shall cause rejection of the lot.
- 5/ The "----" in the table AQL columns indicates that AC, RE criteria are not available for that AQL. Use the alternate sample size and AC, RE criteria listed for that AQL.
- 6/ When sampling is performed on Series 800 Sausage Items, no more than 5 sample units, **(except Item No. 802A and 802B - see footnote 2)** from a single primary container may be included in the sample.
- 7/ TABLES I-B and II-B are not applicable to Series 800 Sausage Items.

## D. FAT CONTENT ANALYSIS

When fat content is to be certified, the purchaser may specify fat content to be determined by either composite analysis or average analysis. If not specified, the fat content shall be determined by average analysis.

For the purpose of determining fat content, the following terms shall be defined as follows:

**Composite sample.** A single sample that is composed of two or more individual samples from a lot.

**Average Fat Content Analysis.** The percent of fat derived from averaging results of 2 or more individual fat content analyses.

**Composite Fat Content Analysis.** Composite fat analysis is the result obtained by determining the percent fat in a sample that has been drawn from two or more thoroughly blended samples.

**Procedures for sample withdrawal for fat content analysis.** For bulk ground products, the AMS agent shall randomly select from each production lot 1 filled bag from each of 4 randomly selected shipping containers. For trimmings, the AMS agent shall randomly select 4 containers (combo bins or shipping containers) from each lot and designate the location for a core sample to be taken. Fill one bag from each core sample (no less than 6 pounds).

From each of the filled bags the agent shall cut 1 approximately 2-pound section, the position of which was randomly established in the filled bags prior to start of sampling. For patties or flaked and formed steaks, the AMS agent shall randomly select a stack(s) or layer(s) from each of 4 randomly selected shipping containers resulting in 4 approximately 2-pound portions of adjacent patties.

After withdrawal of samples, the contractor shall make correct fills on the boxes sampled by adding the necessary product produced for this purpose.

**Composite Fat Content Analysis.** The 4 individual 2-pound sections shall be thoroughly mixed together into one composite sample. The composite sample shall be prepared by reducing the consistency to a thoroughly blended mixture. Three (3) individual samples are drawn from the composite sample, and each is assigned the same identification number. One sample shall be sent to the AMS laboratory for analysis. One sample shall be solidly frozen and retained by the AMS agent as a reserve sample. One sample shall be submitted to the contractor.

**Average Fat Content Analysis.** The 4 individual 2-pound sections shall be independently prepared by reducing the consistency of the section to a thoroughly blended mixture. From each mixture, 3 samples shall be pulled and assigned the same identification number: One sample shall be submitted to the AMS laboratory. One sample shall be solidly frozen and retained by the AMS agent as a reserve sample, and the remaining sample shall be submitted to the contractor.

**Reserve Samples.** The reserve samples shall be used for analyses: (1) when the original sample is lost; (2) if requested by AMS or the contractor. However, analysis of the reserve samples at the request of the contractor shall not be permitted unless the original analyses indicated that the involved production lot will be rejected (or discounted, if applicable) because of noncompliance with fat analysis requirements. When reserve samples are analyzed, all 4 samples shall be analyzed, and the results of such analyses shall be final. Unused reserve samples shall be returned to the contractor after final acceptance or rejection of the involved production lot.

**Sliced bacon fat content analysis.** Withdrawal of samples for analytical requirements of sliced bacon shall be as follows: Sample size shall be determined according to the lot size (expressed as pounds), and the number of sample units shall be determined from TABLE II-A of the Quality Assurance Provisions. A sample unit for analytical purposes shall be 7 adjacent slices. The locations of the appropriate number of sample units shall be randomly selected. The slices selected shall be cut into approximate 1.0 inch (25 mm) widths, thoroughly mixed, and ground through a 0.125 inch (1/8 inch, or 3.2 mm) plate or similarly comminuted. The thoroughly mixed sample shall be divided into approximate thirds and distributed as follows:

1. One third to the AMS approved laboratory
2. One third held as a reserve sample
3. One third to the contractor

**IMPS 800 Sausage fat content analysis.** When the purchaser specifies this option in the contract or purchase order, the AMS agent shall randomly select from each production lot 1 pound (0.45 kg) of adjacent product from each of 4 randomly selected shipping containers, the position of which was randomly established prior to start of sampling.

After withdrawal of samples, the contractor shall make correct fills on the boxes sampled by adding the necessary product produced for this purpose.

**Canned Luncheon Meat fat content analysis.** After completion of the can filling operation for each lot, eight cans of product shall be randomly selected for analysis. The product from the eight cans shall be formed into a composite sample by thorough mixing. The contents of these cans shall be prepared by reducing the consistency of the composite sample to a thoroughly blended mixture. After the composite sample is prepared, three cans of the sample mix shall be repacked and resealed. All sample cans shall be marked to identify them with the applicable lot and to distinguish them from cans of that lot or cans or samples from any other lot. After thermal processing, these three cans shall be distributed as follows:

1. - One shall be submitted to the laboratory.
2. - One shall be submitted to the contractor.
3. - One shall be retained by the AMS agent as a reserve sample to be used if the original is lost or if requested by AMS or the contractor.

However, analysis of the reserve sample at the request of the contractor shall not be permitted unless the original analysis indicated that the involved production lot will be discounted or rejected because of noncompliance with the fat or salt content requirements. When the reserve sample is analyzed, the results of such analysis shall be considered final. Cans of composite sample mixture, in excess of the three selected above, may be thermal processed and included in the production lot. Unused reserve samples shall be submitted to the contractor.

#### **E. PROTEIN FAT-FREE (PFF) SAMPLE SELECTION/PREPARATION PROCEDURES**

When the purchaser's contract or purchase order specifically designates that the PFF values are to be certified by the USDA, MGCB, the AMS Agent shall randomly select 1 ham, shoulder, or loin item from each of 4 randomly selected shipping containers and cut from each of the selected samples an approximate 1-pound section, (remove bone if sample is selected from a bone in item) the position of which was randomly established prior to the start of sampling. Each section shall be independently prepared by reducing the consistency of the section through a 0.125 inch (1/8 inch, or 3.2 mm) plate or similarly comminuted and thoroughly blended. From this mixture, 3 samples shall be drawn: 1 sample shall be sent to a FSIS, MPIO approved and certified laboratory, 1 sample shall be solidly frozen and retained as a reserve sample, and the remaining sample shall be given to the contractor.

**If the average of the 4 samples fails to meet or exceed the FSIS, MPIO minimum required PFF percentages listed in TABLE I, the involved lot shall be rejected.**

After withdrawal of samples the producer may repackage the sampled product and include in the delivery unit, or replace with extra product from the same production lot.

#### **F. DRAINED WEIGHT EXAMINATION PROCEDURES**

Canned Hams. Prior to the defect examination, hams selected for evaluation of finished product defects shall also be used to determine total drained weight. Hams shall be in the temperature range of between 55 °F and 75 °F at the time of the examination. The cooked ham shall be made as free as possible from rendered fat, liquid, and gelatinized juices prior to being weighed. Total net weight shall be determined by subtracting the tare weight from the gross weight. The tare weight shall be determined by weighing an equal number of empty cans, lids, and bags used in packaging the product. The total drained weight must be equal to or greater than 97% of the total actual net weight for pullman style hams, 94% for pear shaped hams, and 98% for hams prepared in a cook-in bag style container. Failure to meet or exceed the drained weight requirements shall cause rejection of the involved lot.

Canned Luncheon Meat. When specified by the purchaser, an examination for drained weight shall be performed on all sample units. Surface fat and dripping moisture shall be removed from cores used in this examination. Also, meat adhering to the can shall be excluded. Meat cores shall be weighed in the aggregate, and the total weight (in ounces) shall be divided by the number of sample units to determine the average drained weight. The total drained weight must be equal to or greater than 85% of the total actual net weight. Total net weight shall be determined by subtracting the tare weight from the gross weight. The tare weight shall be determined by weighing an equal number of empty cans and lids used in packaging the product. Failure to meet or exceed the drained weight requirements shall cause rejection of the involved lot.

## **G. USDA TEMPERATURE EXAMINATION**

If product is to be USDA, MGCB certified for compliance with the 72- or 24-hour temperature requirement, it shall be sampled by randomly selecting at least 3 shipping containers or 3 pieces from each production lot. Any individual sample box exceeding the specified temperature shall cause rejection of the lot.

For USDA, MGCB temperature certification of frozen product at the time of delivery, the AMS agent shall randomly select and examine at least 1 shipping container or 1 piece from each production lot. However, in no case shall there be less than 3 shipping containers or pieces examined from each item or delivery unit. Any individual sample box exceeding the specified temperature shall cause rejection of the lot.

NOTE: A tolerance of +2 °F (16.6 °C) shall be considered as meeting the specification requirements on frozen product only. Final acceptance of frozen product, examined and certified in the chilled state, shall be in accordance with USDA Meat Grading and Certification Branch instructions.

## **H. NET WEIGHT EXAMINATION**

This examination will be performed by randomly selecting and weighing a sample of 10 packed shipping units from each production lot. Net weight shall be determined by subtracting a tare weight from the gross weight. The tare weight shall be determined by weighing empty shipping containers and packaging materials of the same kind and in the same amount applicable to the 10 shipping containers weighed. The total net weight of the sample shall be equal to or greater than the total of the marked net weights in the sample. If the total net weight of the sample is less than the total marked net weights in the sample, the lot shall be rejected. Lots that are rejected may be reworked and submitted for reexamination (one time only). When examining resubmitted lots, a sample of 4 shipping units per lot shall be randomly selected and weighed. The finding of any shipping unit in the resubmitted lot which is less than the marked net weight shall cause rejection of the lot.

**SCALES:** Scales used in the net weight examination and scales used in the certification of a specified weight range and/or portion size shall be certified in accordance with MGCB Instructions. Depending on the product to be examined, electronic digital scales which weigh to .01 of an ounce may be required.

### **Net weight examination for canned luncheon meat.**

When specified by the purchaser, ten (10) sealed, filled cans of product from each production lot shall be randomly selected and weighed in the aggregate to determine the total net weight of product in the sample. Net weight shall be determined by subtracting a tare weight from the gross weight. The tare weight shall be determined by weighing 10 empty cans and lids used in preparing the product.

The total net weight of the sample must be equal to or greater than the total of the marked net weights in the sample. If the total net weight of the sample is less than the total marked net weights in the sample, the lot shall be rejected. However, lots that are rejected for net weight may be reworked and submitted for reexamination (one time only). When examining resubmitted lots, 4 sealed, filled cans of product per lot shall be selected and individually weighed. The finding of any can in the resubmitted lot which is less than the marked net weight shall cause rejection of the lot.

## **I. EXTERNAL AND INTERNAL PRODUCT EXAMINATION FOR IMPS SERIES 800 SAUSAGE PRODUCTS**

All sample units randomly selected for external product examinations shall also be used for internal product examinations.

### **1. STICK, LOAF, BAG, ROLL, AND BULK PACKAGED PRODUCTS**

For examination of the exterior surface defects of stick, loaf, bag, roll, and bulk packaged products, the exterior of the entire sample unit (1 item) shall be evaluated.

For examination of internal product characteristics on the cut surfaces of stick, loaf, bag, roll, and bulk packaged products, the sample unit (1 item) shall be divided into 2 pieces by a single cut made at a right angle to the long axis which is not less than 2.5 inches (6.4 cm) from either end. The right hand cut surface shall then be evaluated for defects in accordance with the applicable IMPS QUALITY ASSURANCE defect table. The AMS agent may cut a defect from a sliced surface to measure all dimensions.

After examination of the cut surface, the producer may repack the sampled product and include it in the accepted delivery unit, or replace it with extra product from the production lot.

## 2. LINK PRODUCTS

To examine link products for exterior surface defects, the entire randomly selected 1-pound (0.45 kg) sample unit shall be evaluated.

For examination of the cut surface of link products for internal product characteristics, randomly select 2 links within each 1-pound sample unit and divide the link into 2 pieces by a single lengthwise cut made parallel to the long axis. Evaluate the right hand cut surface of the link for defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800B. For evaluation, defects may be cut from a sliced surface to measure all dimensions.

When the purchaser specifies portion weights (links per pound), defects 103 and 103A apply. The total weight of the specified number of links per pound shall be 1 pound (0.45 kg),  $\pm 0.05$  pound (22.68 g) (.95 to 1.05 pound). Any sample unit not meeting the specified links per pound weight requirement shall be scored as a major defect.

**NOTE:** Length measurements of link items shall be made on the cut surface of the item which has been divided into 2 pieces by a single lengthwise cut made parallel to the long axis. Link items which have a slight natural curvature may be straightened (without breaking or stretching the item) to permit an accurate measurement. After examination of the cut surface the producer shall replace the sampled product with extra product from the production lot.

## 3. SLICED PRODUCT

To examine sliced products, a randomly selected 1-pound section or 1-pound package (0.45 kg) shall be evaluated on both sides of the slice for defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800E. After examination of the sliced surfaces, the producer may repackage the sampled product and include it in the 1 accepted delivery unit, or replace it with extra product from the production lot produced for this purpose.

- a. Each sample unit shall be subject to a slice-count examination.
- b. Slice-count on each selected sample shall be as specified by the purchaser.
- c. The total number of slices per pound, as specified by the purchaser, shall weigh 1 pound (0.45 kg) with a tolerance of  $\pm 1$  slice. Any sample unit not meeting the specified slice count/weight requirement shall be scored as a major defect.
- d. Examination for internal defects shall be made on both cut surfaces of each slice.
- e. Unless otherwise specified by the purchaser, sliced items shall be manufactured as 1-pound vacuum packages which shall be packed into a master container not to exceed 55 pounds (25 kg).
- f. Slices shall have no evidence of casing material.



#### **4. PORK SAUSAGE PATTY PRODUCTS**

For examination of pork sausage patty products, a sample unit shall be 1 randomly selected patty. Each sample unit shall be evaluated for portion weight, examined for all exterior defects and crumbled for an evaluation of the interior defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800E. After examination of the product for defects, the producer shall replace the crumbled sample product with extra product from the production lot.

#### **5. CRUMBLED, COOKED, PORK SAUSAGE**

To examine crumbled, cooked, pork sausage, a randomly selected 1-pound section shall be evaluated for defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800F.

#### **6. SCRAPPLE**

For examination of internal product characteristics on the cut surfaces of scrapple, the sample unit (1 item) shall be divided into 2 pieces by a single cut made at a right angle to the long axis. The right hand cut surface shall then be evaluated for defects in accordance with the applicable IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800G. The AMS agent may cut a defect from a sliced surface to measure all dimensions.

#### **J. Item Count Examination**

Item Count Examination - This examination will be performed by randomly selecting 4 packed shipping units from each production lot. Item count shall be determined by calculating the number of items (roasts, cuts, packaged units, or portion cuts) in each of the 4 shipping containers. If the count in any individual sample unit is less than the marked item count, the lot shall be rejected. Lots that are rejected may be reworked and submitted for reexamination (one time only). When examining resubmitted lots, a sample of 10 shipping units per lot shall be randomly selected. The finding of any shipping unit in the resubmitted lot which has an item count less than the marked item count shall cause rejection of the lot.

## IV. DEFECT CLASSIFICATIONS

The following tables shall be used for evaluating compliance with the IMPS item descriptions when using the Stationary Lot Examination method. Applicable defects for each individual item description are found in the corresponding lettered table within each series (i.e., 100A - 100S for Fresh Beef items, see index).

Within the individual tables, the defects with 3-digit numbers beginning with the number 1 (i.e., 100, 101, etc.) shall be classified as **MAJOR** and the defects with numbers beginning with the number 2 (i.e., 200, 201, etc.) shall be classified as **MINOR**.

### INDEX OF IMPS ITEMS

All items may be examined for Material and Detailed Item Description Requirements using the Stationary Lot Examination Method. The 100 percent option is available for those items listed for the item's respective table.